April-11-13 3:18:38 PM

Item ID: D2970-3 Accept *N900040100* Setup Start Revision ID; Item Name: Wearplate Start Date: 4/16/13 Start Qty: 10.00 Cust Item ID: Req'd Qty: 10.00 Required Date: 4/16/13 Customer: Reference: Run Start Approvals: **Process Plan:** Date: QC: - Date: SPC (Y/N): Date: Sequence ID/ Operation Tool# Set Up/ Tool ID Plan Reject Reject Insp. Accept Work Center ID Description **Run Hours** Qty Number Stamp Code Qty Draw Nbr **Revision Nbr** D2970 В 100 0.00 FLOW WATER JET *100*. Waterjet 0.00 Memo FLOW CNC Waterjet I-Cut as per Dwg D2970 Dwg Rev: 🤝 Prog Rev: 5 110 QC2-Inspect parts off machine FAI/FAIB 0.00 *110* .≠ Memo QC 0.00 **Quality Control**

										DQA:	Date:	
NCR: Yes	/ No				WORK ORDER NON-C	ON	NFOR	MANCE / UF	PDATE	QA Closed:	Date:	
Work Order:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part No.					Rework Scrap Use-as-is Work Order Update			Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root		T		Descri	ption of work order update	1	nitial	A	ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Des	cription	Date	Verification	QC Inspector
Doc/Data					· · · · · · · · · · · · · · · · · · ·							
Equip/Tooling]											
Operator]										1	
Material												
Setup												
Other						ļ						
Process	1	1	1							1		

Unapproved **FAULT CATEGORY** Landing Gear General Pressure/Forced Bend Grain Ovalized Bending Over/Under tolerance Temperature/Cure BOM/Route Centre Not Concentric to O/S Hardware Part Incorrect Weld Broken/Damaged Inspection Incomplete Cracks Wrong Stock Pulled Part Lost/Missing Instructions Incomplete/Unclear Crushed/Crimped Burrs Part Moved Contamination Maintenance Cuffs Positioned Wrong Countersink Mislabeled Heat Treat Other Power Loss/Surge Inspection Strip in Tube Cut Too Short Misread Ripples in Bend Drill Holes Offset Out of Calibration Torque Waves in Extrusion Drawing Out of Sequence Finish Turning Sequence Folio **Outside Dimensions** Wave/Twist in Tube

Supplier Training

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Setup Start

April-11-13 3:18:38 PM

Item ID: D2970-3 Accept Revision ID: Item Name: Wearplate *10* Start Date: Start Qty: 10.00 4/16/13 Required Date: 4/16/13 Req'd Qty: 10.00 *10* Reference:

Cust Item ID: Customer:

N900040100

Start Run Approvals: Process Plan: Date: Tooling: Date: Stop QC: SPC (Y/N): Date: Date: Sequence ID/ Set Up/ عبر Run Hou**v27** Operation Tool # Plan Reject Reject Tool ID Accept Insp. Work Center ID Description Code Qty Oty Number Stamp 120 QC8- Inspect parts - second check 0.00 *120* B.831 QC 0.00 Memo Quality Control 130 0.00 NC BRAKE Brake NC 0.00 Memo Brake NC Deburr and form on brake using DT8178 and DT8261as per Dwg D2970 140 QC5- Inspect part completeness to step on W/O *140* Memo **Quality Control**

					•					DQA:	Date:	
NCR: Y	res / N	0			WORK ORDER NON-	COI	NFORI	MANCE / UPDATE		QA Closed:	Date:	
		٠.			DISPOSITION			AG	_	PARTMENT		
Work Orde Part N	No				Rework Scrap Use-as-is Work Order Update			Machining Sm noforming Fig	esstube all Fab nishing nposite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update		Initial	Action		Sign &		
Cause	Date	e Step	Qty		or Non-conformance	Ch	nief Eng	Description		Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved							3					
						AUI	LT CATE	GORY				
Landi	ng Gear			, —	General	_	٦		_	1	r—	7
	Cracks	Not Conce		O/S	Bend BOM/Route Broken/Damaged Burrs Contamination		Instruct	are ion Incomplete tions Incomplete/Unclear enance		Ovalized Over/Under Part Incorre Part Lost/M Part Moved	ct	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled
	Heat 1	reat			Countersink		Mislabe	eled		Positioned \	Vrong	_

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Other

Power Loss/Surge

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

April-11-13 3:18:38 PM

Item ID: Revision ID: Item Name: Start Date: Required Date Reference:	D2970-3 Wearplate 4/16/13 :: 4/16/13	Start Qty: 10.00 Req'd Qty: 10.00	*10* *10*	Accept	Cust Item ID: Customer:)* Setup Start *NS1* Stop *NS2*
Approvals:	Process Pla	nn: Dat		Tooling: SPC (Y/N):	Date:	Run Start *NR1* Stop *NR2*
Sequence ID/ Work Center I 150 *150* HandFinish Hand Finishing	D	Operation Description Memo Coat entire top cone A/R Rockguard be	ave surface with a la tch: \Q 6136	Set Up/ Run Hours 0.00 0.00 yer or rockguard as per dwg DAS 27 0.00 9-89 0.00 3. 3. 3.		Accept Reject Reject Insp. Qty Qty Number Stamp 14 6 6 4 13-8-22
170 *170* Packaging Packaging		Identify as per dwg & Stock Loc Memo	ation: <u> </u> FP_00 <i>7</i>	0.00 0.00		He of Ill is look a

											DQA:	Date	2:	
NCR:	Yes	/ No				WORK ORDER NON-C	COI	VFORN	MANCE / UPDAT		·			
										· · · · · · · · · · · · · · · · · · ·	QA Closed:	Date	2:	
				. .		DISPOSITION				AGAINST DE	PARTMENT	PROCESS		
Work Ord	er:	····				Rework	1 l		Skid-tube C	rosstube		Water Jet	7 Engi	neering
Part (Viα					Scrap	1			Small Fab	Pro	d. Eng. Coor.	_	Quality
1						Use-as-is	1	Therm	oforming	Finishing	Rec/Stor	e/Packaging		Other
NCR I	No.	<u></u>		- -		Work Order Update]		Large Fab Co	omposite		Supplier		
Root					Descri	ption of work order update	Π	Initial	Action		Sign &			
Cause		Date	Step	Qty		or Non-conformance	Ch	nief Eng	Descripti	on	Date	Verification	Q	Inspector
Doc/Data														
Equip/Tooling			ļ										-	
Operator			1											
Material	Ш													
Setup				1 1										
Other			1											
Process														
Supplier														
Training				1 1										
Unapproved	L_		<u> </u>	<u> </u>			<u>.</u>					<u> </u>		
						F	AUL	LT CATE	GORY					
Landi	ng (ı				General		7		Γ	1	г	\neg _	
		Bending				Bend	\vdash	Grain		ļ	Ovalized	ļ.		ire/Forced
1	L	Centre N	ot Conce	ntric to O	/S	BOM/Route	\perp	Hardwa			Over/Under	-		erature/Cure
		Cracks				Broken/Damaged		-	on Incomplete	-	Part Incorre	F	Weld	
		Crushed/	'Crimped			Burrs		-{	ions Incomplete/Uncl	ear	Part Lost/M		Wrong	g Stock Pulled
		Cuffs				Contamination	\perp	Mainte	nance	<u> </u>	Part Moved			
		Heat Trea	at			Countersink	_	Mislabe	led		Positioned \		_	
		Inspectio	n Strip in	Tube		Cut Too Short		Misread	l		Power Loss/	'Surge [Other	
1		Ripples in	Bend			Drill Holes		Offset						

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Item ID: Revision ID: Item Name:	D2970-3 Wearplate			Accept	*N900040100*	Setup Start *NS1* Stop *NS2*
Start Date: Required Date Reference:	4/16/13 : 4/16/13	Start Qty: 10.00 Req'd Qty: 10.00	*10* *10*		Cust Item ID: Customer:	
Approvals:	Process Pl	lan:	Date:	Tooling: SPC (Y/N):	Date:	Run Start *NR1* Stop *ND2*
Sequence ID/ Work Center I 180 *120* QC Quality Control		Operation Description QC21- Final Inspection - Memo		Set Up/ Run Hours 0.00	Tool ID Tool # Plan A	Accept Reject Reject Insp. Oty Qty Number Stamp ACS 13-08-23

								DQA:	Date: _	
NCR: Yes	/ No			WORK ORDER NON-	CONFORM	MANCE / UP		QA Closed:	Date:	
Work Order:				DISPOSITION			AGAINST DE	PARTMENT,	/PROCESS	
work Order.				Rework	٦ !	Skid-tube	Crosstube		Water Jet	Engineering
Part No.				Scrap] '	Machining	Small Fab		d. Eng. Coor.	Quality
NCR No.				Use-as-is Work Order Update	I	noforming Large Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier	Other
Root				Description of work order update	Initial	Ac	tion	Sign &		
Cause	Date	Step	Qty	or Non-conformance	Chief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data										
Equip/Tooling										
Operator]					,			;	
Material]			1		1				
Setup					Ì					
Other]			1						
Process					1					
Supplier]									
Training]									

			FAU	LICATEGORY	 	
Landing (Gear	General		_	 _	
	Bending	Bend		Grain	Ovalized	Pressure/Forced
Г	Centre Not Concentric to O/S	BOM/Route		Hardware	Over/Under tolerance	Temperature/Cure
	Cracks	Broken/Damaged		Inspection Incomplete	Part Incorrect	Weld
	Crushed/Crimped	Burrs		Instructions Incomplete/Unclear	Part Lost/Missing	Wrong Stock Pulled
	Cuffs	Contamination		Maintenance	Part Moved	
	Heat Treat	Countersink		Mislabeled	Positioned Wrong	_
	Inspection Strip in Tube	Cut Too Short		Misread	Power Loss/Surge	Other
	Ripples in Bend	Drill Holes		Offset		
	Torque Waves in Extrusion	Drawing		Out of Calibration		
	Turning Sequence	Finish		Out of Sequence		
	Wave/Twist in Tube	Folio		Outside Dimensions		

Unapproved

Work Order ID: 99758

D2970-3

Parent Item Name: Wearplate

99758

D2970-3

Start Date: 4/16/13

Required Date: 4/16/13

Start Qty: 10.00

Required Qty: 10.00

Comments:

Parent Item:

B01.06.07Added Material and Tool numberSM/EC

C

08.09.03

Waterjet

EC verified: DD

Component Item ID/ Item Name	Replacement Item ID	Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	— Total Qty	Qty Issued	Date Issued	Status
M304S20GA	 –	Purchased	No			— '	sf	 367.6500		 -13.1579-	· - مـــ		
M304S20 304/316.040 Sheet	GA					1			**	12575	<u> </u>	<u> 14.3</u>	3 /s
ary.				Location		<u>Lpc Q</u>	<u>ty</u>	Loc Code					,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,

MAT020

124029 124956 367.65 117.15 250.5

20

NCR:	Yes /	Nο
INCN.	162 /	110

DQA: _____ Date: ____

NCR: Y	es / No				WORK ORDER NON-O	CONFOR	MANCE / UI	PDATE	QA Closed:	Date:	
Work Orde	r:				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part N					Rework · Scrap		Skid-tube Machining	Crosstube Small Fab	4	Water Jet d. Eng. Coor	Engineering Quality
NCR N	o	<u></u>			Use-as-is Work Order Update	Ther	moforming Large Fab	Finishing Composite	Rec/Stor	re/Packaging Supplier	Other
Root					ption of work order update	Initial		ction	Sign &	_	
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	g Des	cription	Date	Verification	QC Inspector
Doc/Data											
quip/Tooling	_										
Operator											
Material	_										
Setup											
Other											
Process						•					
Supplier	_			1						ļ	
Training											
Unapproved			<u> </u>			AULT CAT	L		<u> </u>	<u> </u>	
l sadia	g Gear	-			General	AULI CAI	LGONT				
Landin	Bending				Bend	Grain			Ovalized		Pressure/Forced
}	Centre No	nt Concei	ntric to I		BOM/Route	Hardw			Over/Under	tolerance	Temperature/Cure
ŀ	Cracks	or coneci	itile to	>,3 ├-	Broken/Damaged		tion Incomplete		Part Incorre	⊢	Weld
}	Crushed/	Crimped		-	Burrs	_	ctions Incomplete	e/Unclear	Part Lost/M	<u> </u>	Wrong Stock Pulled
ŀ	Cuffs	ci iiii peo.			Contamination	_	tenance		Part Moved		J ,
-	Heat Trea	at			Countersink	Mislat		-	Positioned \	Vrong	i
F	Inspection	_	Tube	 	Cut Too Short	Misre		F	Power Loss/		Other
}	Ripples in	•		-	Drill Holes	Offset		L		·	<u> </u>
	Torque W		xtrusio	,	Drawing		Calibration				
·	Turning S				Finish	\vdash	Sequence				
-	Wave/Tw				Folio		le Dimensions				

DART AEROSPACE LTD	Work Order:	99758
Description: Wearplate	Part Number:	D2970-3
Inspection Dwg: D2970 Rev: B		Page 1 of 1

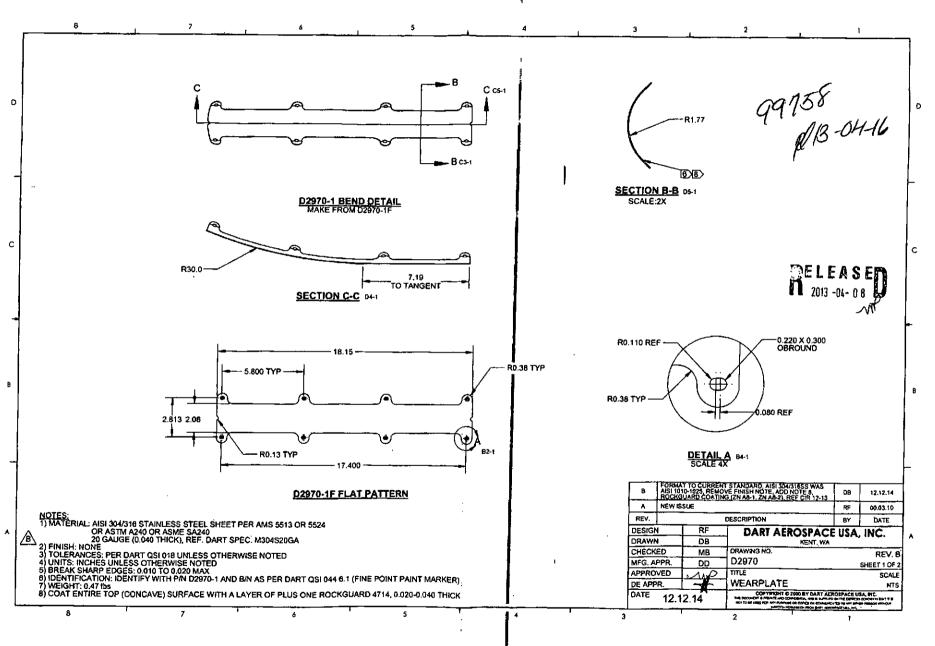
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.220 x 0.300	+/-0.010	,225 x .305			V	JKM -01
2.063	+/-0.010	2.063	_		٧	
2.813	+/-0.010	2.813			V	
5.000	+/-0.010	5,000	-		>	
0.375	+/-0.010	.375			V	
55.000	+/-0.010	55.600			V (7 JKn-06
0.040	+/-0.010					
•						
		·				
	· · · · · · · · · · · · · · · · · · ·					
						· -
			DAS		-	

Measured by:	Audited by:	9-89	Preliminary Approval:			
Date: 13/08.20	Date:	13821	Date:			

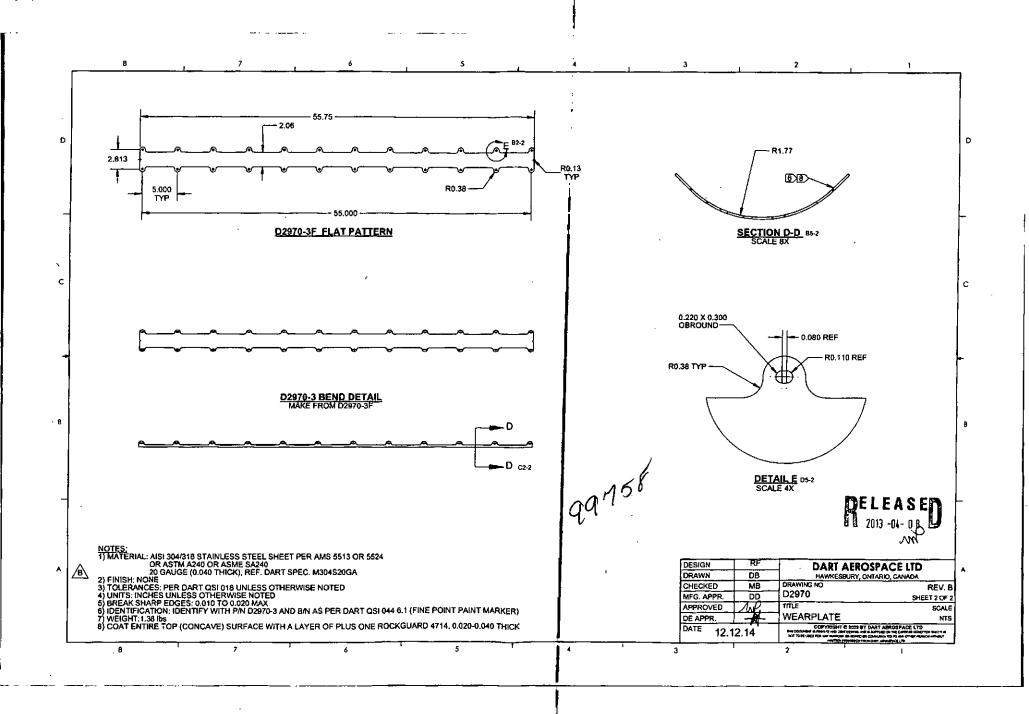
Rev	Date	Change	Revised by	Approved
Α	08.09.19	New Issue	KJ/DD	
В	08.11.27	0.040 dimension added	KJ/EC	
С	13.04.12	Dimensions updated per Dwg Rev B	KJ 44/	
			• • • • • • • • • • • • • • • • • • • •	

	•		•
	1		
			•
		r r	
		- - <u>*</u>	
		- ;	
		. *	
		. .	
		Ĩ. <u>\$</u>	
		. <u>*</u>	
-			



, •

	·			
			·	
, ,				



		-	 	·
	٠. ٠		`a.	
	ngar nang		%-d #	
	•			
			·	: :
	•			
			- -	•
	 			•
		·		
			*	
· · · ·				